

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023622**Date Inspected:** 23-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Handrail & OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS26-3, OBG Bike Path Handrail components.Welder is identified as 064459. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS19-1, OBG Bike Path Handrail components.Welder is identified as 201861. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS8-1, OBG Bike Path Handrail components.Welder is identified as 216421. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS1-1, OBG Bike Path Handrail components.Welder is identified as 201905. ZPMC Quality Control (QC) is identified as Mr. Mai Quin

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Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding # 6 fillet weld, P45 (25 x25 bar) to P19 (Pipe PX36), located on BKR-FS1-2, OBG Bike Path Handrail components. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

FCAW welding of weld identified as X3744A-016-001, located on OBG component X3744A-011. Welder is identified as 062092. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132 –ESAB-(2F).

FCAW welding of weld identified as X3744B-019-002, located on OBG component X3744B-013. Welder is identified as 216421. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132 –ESAB-(2F).

OBG Bay # 13

WELDING

This QA observed the following components in this bay, OBG, Steel Barriers. This QA observed no work being performed on the above mentioned components during the time QA was present.

OBG Bay # 28

WELDING

This QA observed the following components in this bay, OBG, Mock-Up Service Hand Rails. This QA observed no work being performed on the above mentioned components during the time QA was present.

Bay #16

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08908.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. Time of inspection was 14:00 hours. The members are identified as follows OBG Steel Barrier. The weld designations reviewed are as follow: X3744A-001-001~039, X3744B-001-001~039

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
Reviewed By:	Hall, Steven	QA Reviewer
